

Date: Tuesday, 24/02/2009 1:41:11 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 3" SKID EXTRUSION (NO OUTER RIDGE)		
Job Number	: 46063			Part Number	: D26003120		
Estimate Number	: 10054			Drawing Number	: D2600 REV D1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 24/02/2009 S.O. No. :			Drawing Revision	: D1		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SKIDTUBES			Due Date	: 20/03/2009 Qty: 69 Um: Each		
Previous Run	: 43960						
Written By	:						
Checked & Approved By	: <u>Cd09/02/24</u>						
Comment	: Est. D: 02.09.10 Added DSK 066 KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs PURCHASING Issue P/O: <u>8262</u> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 120' long g) Bon L Canada Inc. tool # 897122 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required
2.0	D26003120P	Extrusion Round 3" 350 Comment: Qty.: 1.0000 Each(s)/Unit Total : 69.0000 Each(s) Extrusion Round 3" 350
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/02/2009 1:41:11 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 46063

Part Number: D26003120

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC6

DIMENSIONAL CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DIMENSIONAL CHECK

Inspect dimension per Dwg D2600

Check Pull test per Dwg D2600 for compliance page attached

Check hardness with Webster tester (16)

S 090318

checked
X77

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: skid full cell

M

09-03-18

77

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/03/18

Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DART</i>	DRAWN BY <i>DAR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SAS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>-46</i>	

RELEASED
18.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
 RETURN TO
 ENGINEERING
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 976663

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

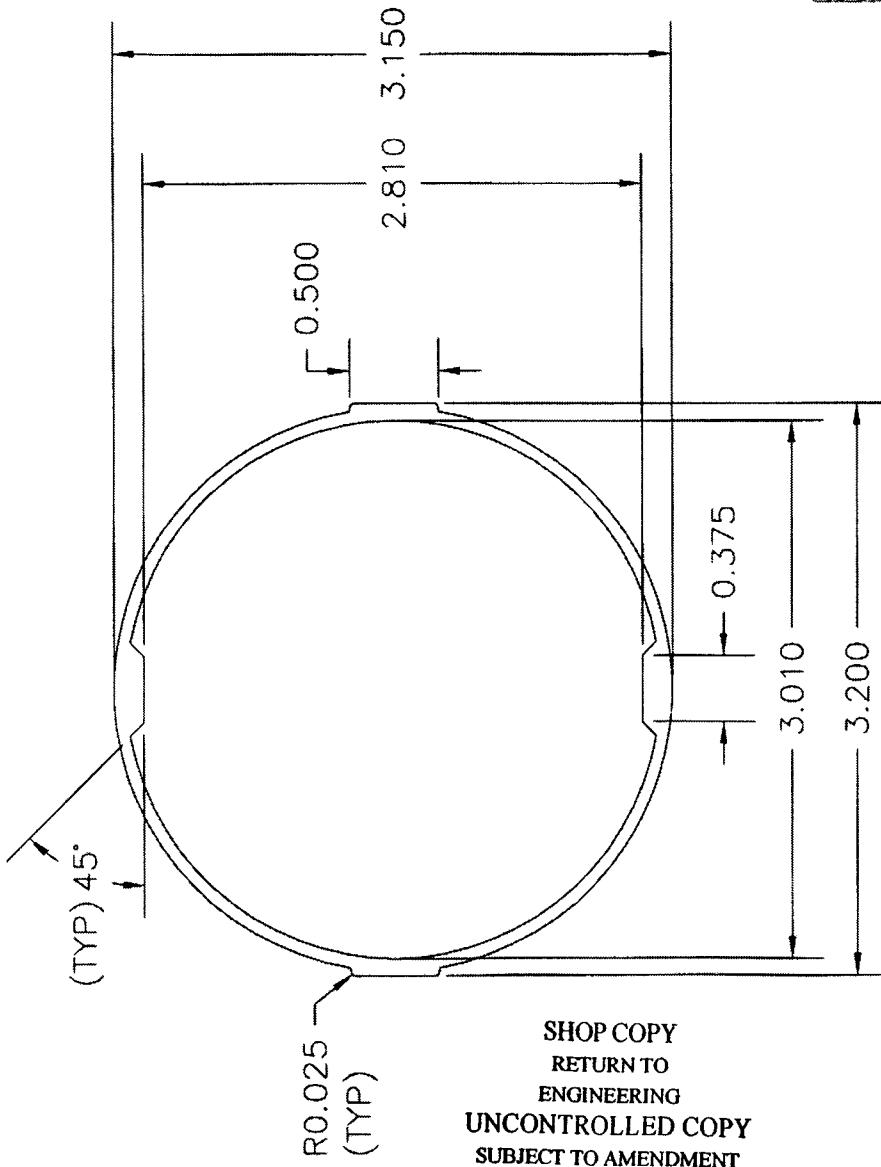
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>BB</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JH</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

**RELEASED**
98.8.25 DSD2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

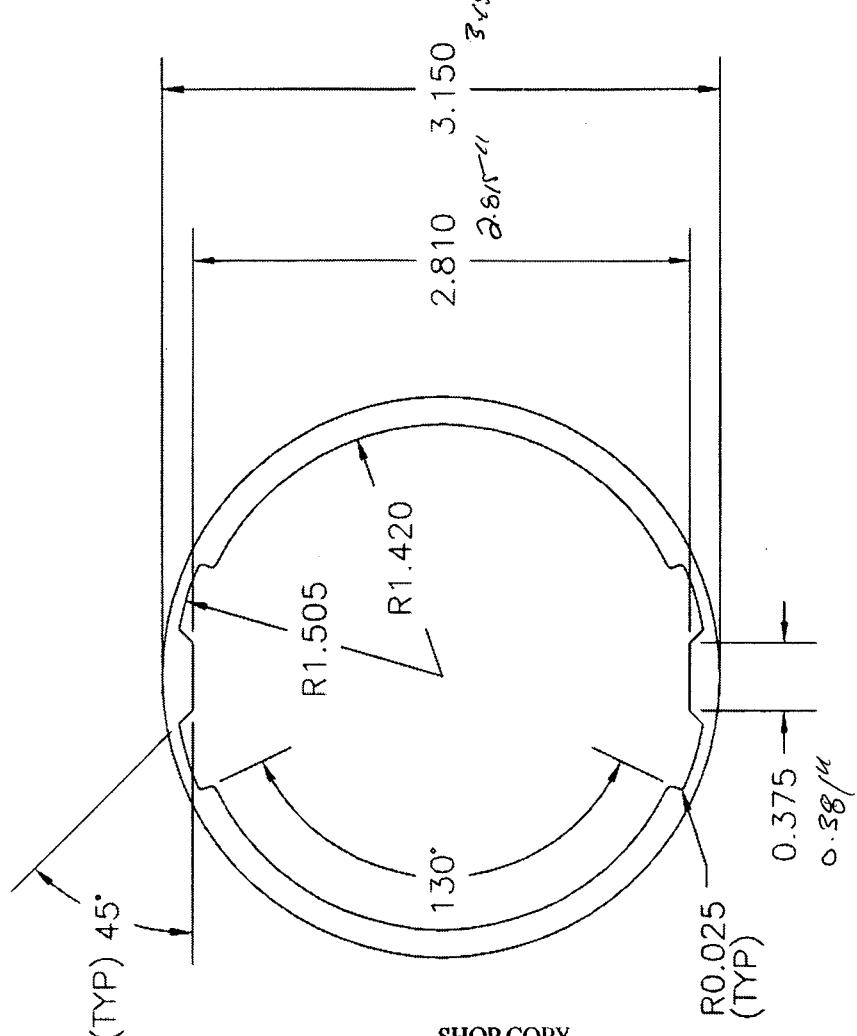
OR FOR L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-1600 (1600 LONG))



DART

DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

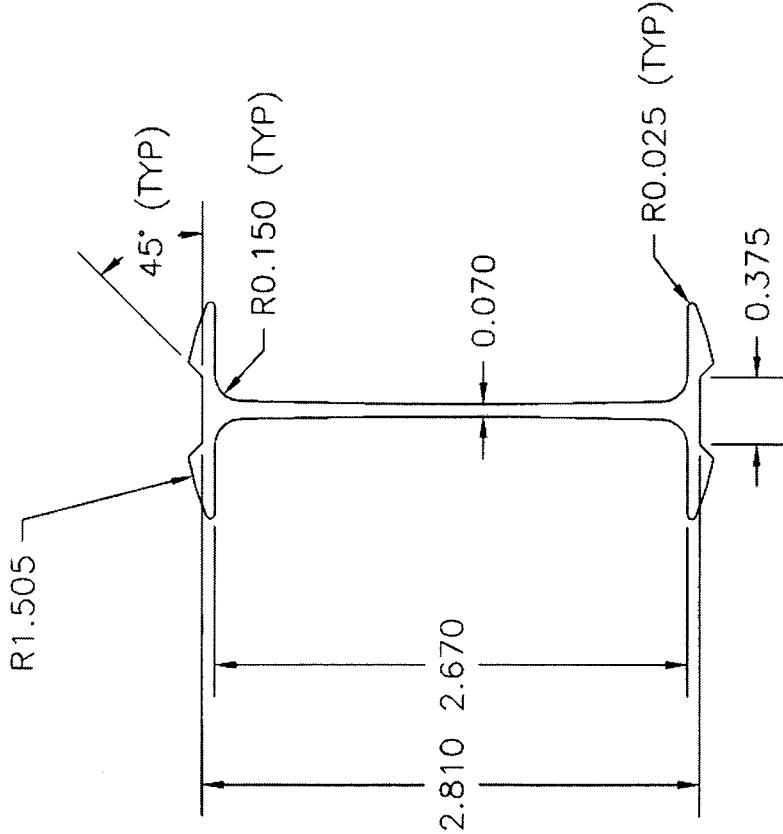
D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BNL DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-120 IS 120 long)



DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D	SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE	1:1

RELEASED
98 8 25 DSD2600-5

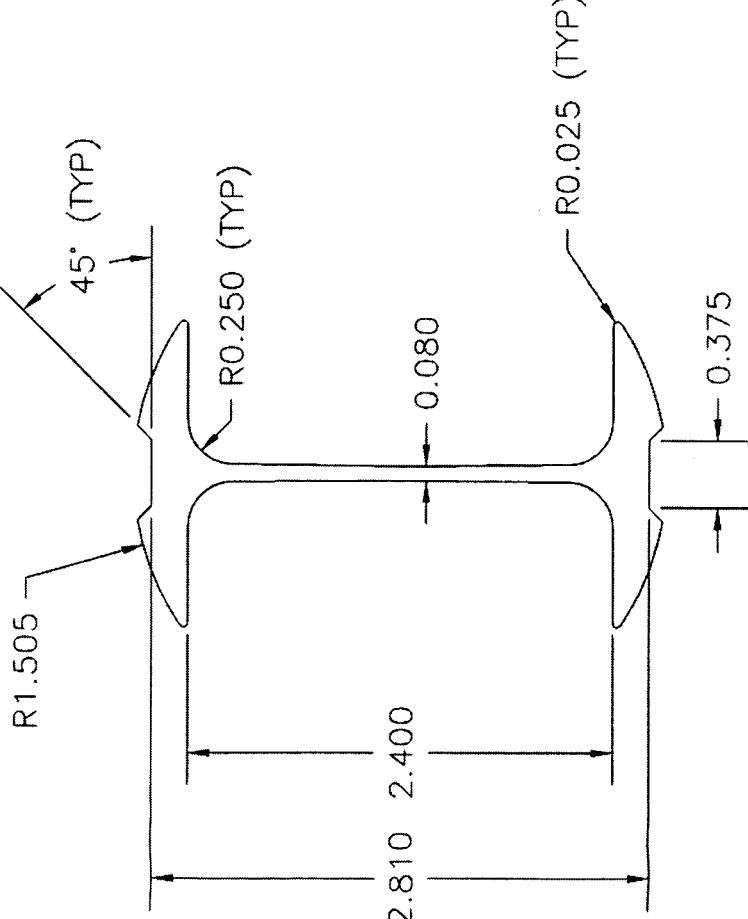
MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" Long)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
RE	S	D2600	SHEET 5 OF 5
DATE	98.08.20	TITLE	SCALE
		EXTRUSION	1:1

RELEASED
98 E 25 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(Ex. D2600-7-125 IS 125" LONG)



ACCT# 00046024

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN		SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN										
PHONE 613-632-5200		PHONE 613-632-5200										
CUSTOMER ID 46024	ORDER DATE 02/24/09	CUSTOMER PO NUMBER 8262										
ITEM NO. ORIGINAL ORDER QUANTITY UNIT PREVIOUS SHIPPED QUANTITY MFG. PART NUMBER ALLOY & TEMPER LENGTH FABRICATION DESCRIPTION THIS SHIPMENT NBR OF PKGS GROSS POUNDS NET QUANTITY UNIT QUANTITY D												
01	69	KG M PC	0 0 0	DAA-897122-1 D2600-3-120	CUTTING TOLERANCE LOT/TKT DETAIL:	6061 /T6 120" +3/16 " -0 "	MILL CERTIFICATE OF COMP (+015-015,0079-0058)	2 1 1	561 284 277	547 234.70 277	KG M PC	39 38 1

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

TERMS / FREIGHT
O / P

REFER TO THESE NUMBERS ON ALL CORRESPONDENCE

CREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

FIELD SALES REP
Kutter A
450-435-6551

CUST SERVICE REP
Burton D
905-427-2227

BILL OF LADING NUMBER
08390042

PAGE 1

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
 No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

SHIPPING MANIFEST

MANIFEST DATE
03-16-09

MANIFEST NUMBER
656328

SALES ORDER NUMBER
44198

TOTALS
 2 561 547
 234.70
 77 KG M PC

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cart Date	Cert No.	Sales Order	Page
03/16/09	188667	44198	1
03/16/09	8262	44198010	3/16/09
	08390042		

Sold To:	Ship To:
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description			Cust Part
1.000	DAA-897122-1	120" Mill 6061 T6			D2600-3-120
Gross Weight	561 KGS				
Net Wt.	547 KG	77 PC	235 M	2 PKG	
Specification	AMS-QQ-A-200/8 & ASTM B221-08				

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	319.7 / 46.4	294.2 / 42.7	13.7	.0	.0	96

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.62	.30	.26	.04	.87	.06	.14	.01

S
04/03/08

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

Conchita Ko.